

Date: Tuesday, 1/31/2006 1:14:37 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 204 SKIDTUBE "I" BEAM
Job Number	: 25698		
Estimate Number	: 10996		
P.O. Number	: N/A	Part Number	: D2597
This Issue	: 1/31/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2597 REV D
First Issue	: N/A	Project Number	: N/A
Previous Run	: 25336	Drawing Revision	: D
	Type : LANDING GEAR	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 2/7/2006
Checked & Approved By	: <u>06.01.31</u>	Qty:	2 Um: Each
Comment	: Est: D 98.10.15 Eliminated DEO, Changed Dwg Revision KS		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D25003100	Ext'n -I" Beam Web 4"
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
 Extrusion "I" Beam Web 4"

Pick;

Qty	Part Number	Description	Batch
1	D2500-3-100	Extrusion	321570

a.m 06-02-06 ②

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

Cut D2500-3 to length: 84.25" a.m 06-02-06 ②

Use Jig DT8094 to drill pilot holes. a.m 06-02-06

Open to 0.625 diameter using a uni-bit. a.m 06-02-06

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

BE 06-02-07 ①

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid Etch and Alodine per QSI 005 4.1 a.m 06-02-07 ①

5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Bog 02 08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 204 SKIDTUBE "I" BEAM

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

from 06-02-08 (2)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SUR 06/02/08 (2)

(2) 06/02/09

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: LD Date: 06/02/09
 QA: N/C Closed: _____ Date: _____

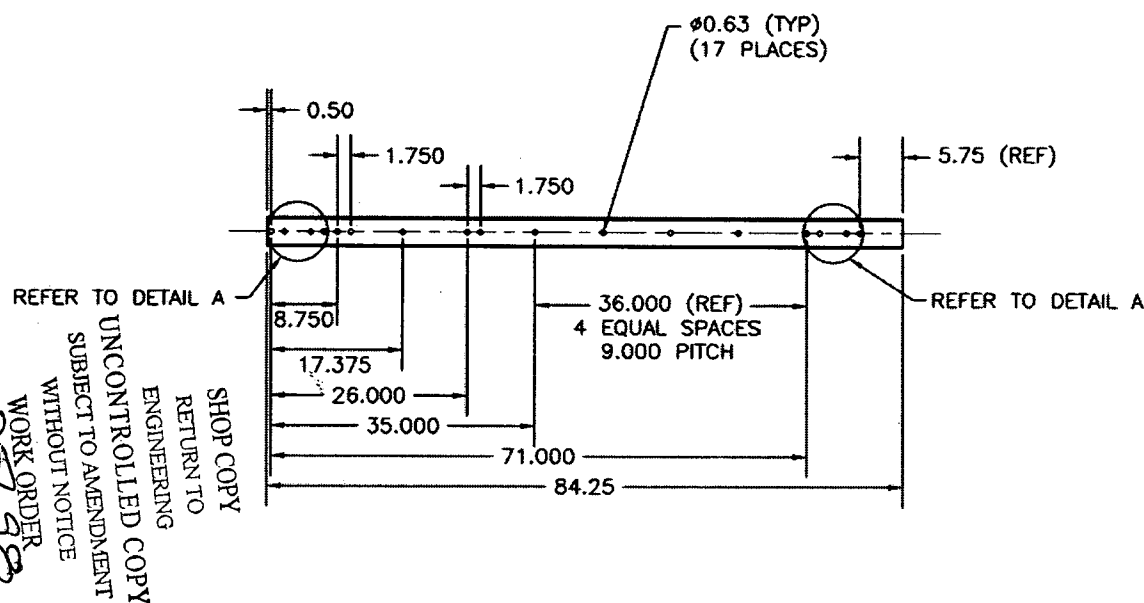
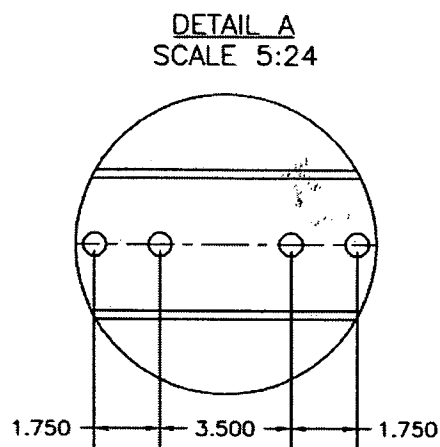
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
98.9.17 DS

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. D
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
DATE 98.09.14	TITLE 204 WEB	DRAWING NO. D2597	SHEET 1 OF 1
A	96.09.16	NEW ISSUE	SCALE 1:24
B	96.10.29	5.75 WAS 0.50	
C	97.07.23	Ø0.63 WAS Ø0.56	
D	98.09.14	INCORPORATED DEO 9097	



MANUFACTURED FROM D2500-3 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED